

Order # 9366

ARC



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008436

D350-591-312
Job Sheet 189013



Part No: D350-591-312

Job Qty: 10 ea

Part Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/17/19

Job Tracking No:

Due Date: 2/27/19

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3572-1 JLM IPP Rev:C 08-04-02 ECN1163 DD verified by:EC IPP Rev:D 08-04-08 ECN1164 DD verified by:eC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		2/27/19	0.00	0.00	Start Up Large Fab-4		CLy
110	Large Fab	10 pcs		2/27/19	0.00	10.00	Large Fab 2		SLy
120	QC	10 pcs		2/27/19	0.00	0.00	QC9		CR
130	QC	10 pcs		2/27/19	0.00	0.00	QC5		CR
140	HandFinish	10 pcs		2/27/19	0.00	1.87	HandFinish1		D.R. 19/01/19
150	QC	10 pcs		2/27/19	0.00	0.00	QC7-2		JAN 28 2019 68
180	Large Fab	10 pcs		2/27/19	0.00	10.00	Large Fab 2		SLy 9-89
190	QC	10 pcs		2/27/19	0.00	0.00	QC10		SLy
200	QC	10 pcs		2/27/19	0.00	0.00	QC5		SLy
210	HandFinish	10 pcs		2/27/19	0.00	1.87	HandFinish1		DR 19/02/18
220	Powdercoat	10 pcs		2/27/19	0.00	2.98	Powdercoat1		BR 19-05-25
230	HandFinish	10 pcs		2/27/19	0.00	1.87	HandFinish3		SL 19-02-20
240	QC	10 pcs		2/27/19	0.00	0.00	QC3		SC 19/03/07
250	Packaging	10 pcs		2/27/19	0.00	0.00	Packaging1-3		MAR 04 2019
260	QC	10 pcs		2/27/19	0.00	0.00	QC4		MAR 05 2019
270	Packaging	10 pcs		2/27/19	0.00	0.00	Packaging3-1		MAR 05 2019
275	DC	10 pcs		2/27/19	0.00	0.00	DC		MAR 05 2019
280	QC21-FG	10 Ea		2/27/19	0.00	0.00	QC21		MAR 05 2019

Part Op 110 - 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT10115, weld Fwd End Plate as per QSI 004 & Dwg Descriptions: D3272 A/R Aluminum Rod 138872 3-Grind End Plate flush

180 - 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod 6-Grind End Plate flush 7-Install last rivet as per Dwg.

220 - START TIME: 1.00 OVEN TEMPERATURE: 320 FINISH TIME: 1.30

270 - Identify and pack for shipping as per PPPD350-591-312 Location FG109

275 - Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3067-1	End Plate	20 Ea (2 ea)	90-Start up Operation	5128763
D3219-1	Plate	20 pcs (2 ea)	90-Start up Operation	5133950
D3272-1	Step	10 Ea (1 ea)	90-Start up Operation	5145049
D3065-041	Step Leg Assembly	10 pcs (1 ea)	180-Large Fab	5156568
D3066-1	Spacer	20 pcs (2 ea)	180-Large Fab	5128757
MS20600-AD4W4	Rivet	160 Ea (16 ea)	180-Large Fab	5117989
AN3-35A	Bolt	20 Ea (2 ea)	250-Packaging	5101329
AN4-13A	Bolt	80 Ea (8 ea)	250-Packaging	5149283
AN5-36A	Bolt	20 Ea (2 ea)	250-Packaging	5133174
D2230-3	Mounting Lug	40 pcs (4 ea)	250-Packaging	51537037 5153673X3
D2618	Bushing	20 Ea (2 ea)	250-Packaging	5146466
D2856-400-720	Abrasion Strip 4" X 7.20"	20 pcs (2 ea)	250-Packaging	5141358
D3235-1	Mounting Lug	20 pcs (2 ea)	250-Packaging	511320540 515005940
D3278-041	Support Assembly	10 pcs (1 ea)	250-Packaging	5136112
MS21042L3	Nut	20 Ea (2 ea)	250-Packaging	5130347
MS21042L4	Nut	80 Ea (8 ea)	250-Packaging	5149814
MS21042L5	Nut	20 Ea (2 ea)	250-Packaging	5093592
NAS1149D0363J	Washer	40 Ea (4 ea)	250-Packaging	5123430
NAS1149D0463J	Washer	160 Ea (16 ea)	250-Packaging	5150216
NAS1149D0563J	Washer	40 Ea (4 ea)	250-Packaging	5123450

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3067-1	20	265	0
	D3219-1	20	213	0
	D3272-1	10	10	0
180-Large Fab	D3065-041	10	0	0
	D3066-1	20	223	0
	MS20600-AD4W4	160	4,576	0
250-Packaging	AN3-35A	20	111	0
	AN4-13A	80	515	0
	AN5-36A	20	114	0
	D2230-3	40	34	0
	D2618	20	13	0
	D2856-400-720	20	138	0
	D3235-1	20	23	0
	D3278-041	10	26	0
	MS21042L3	20	2,207	0
	MS21042L4	80	1,763	0
	MS21042L5	20	294	0
	NAS1149D0363J	40	1,181	0
	NAS1149D0463J	160	2,963	0
	NAS1149D0563J	40	1,094	0

Part Specifications

Specifications could not be found.

- 7587

Plex 1/17/19 11:30 AM dart.lacelle.linda



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Container No: S146083



Part: D350-591-312

Job No: 189013

Serial No/Batch: S146083

Revision:

Inspector:

Exp Date:

Instructions: TC STC SH92-6 Issue 10, FAA STC SH967NE 0

Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X						D350-591-213	<i>Heli-Access-Step™</i> , Short Step – High Skid, LH
	X					D350-591-214	<i>Heli-Access-Step™</i> , Short Step – High Skid, RH
		X				D350-591-215	<i>Heli-Access-Step™</i> , Short Step – Low Skid, LH
			X			D350-591-216	<i>Heli-Access-Step™</i> , Short Step – Low Skid, RH
				X		D350-591-311	<i>Heli-Access-Step™</i> , Long Step – High Skid, LH
					X	D350-591-312	<i>Heli-Access-Step™</i> , Long Step – High Skid, RH
1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
				1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
					1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
2	2	2	2	4	4	D2230-3	MOUNTING LUG
2	2	2	2	2	2	D2618	BUSHING
4	4	4	4			D2732-030	CUSHION
				2	2	D2856-400-720	ABRASION STRIP
2	2	2	2	2	2	D3235-1	MOUNTING LUG
				1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	AN3-35A	BOLT
				8	8	AN4-13A	BOLT
4	4	4	4			AN4-15A	BOLT
2	2	2	2	2	2	AN5-36A	BOLT
4	4	4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
12	12	12	12	16	16	NAS1149D0463J	WASHER (AN960JD416)
4	4	4	4	4	4	NAS1149D0563J	WASHER (AN960JD516)
2	2	2	2	2	2	MS21042L3	NUT
6	6	6	6	8	8	MS21042L4	NUT
2	2	2	2	2	2	MS21042L5	NUT
				1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 15 for installation of the DSI 9410-011 Kit.